



Dart Aerospace Ltd.
1270 Aberdeen St
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Canada

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D2332-041
Job Sheet 205242



Part No: D2332-041

Job Qty: 6 pcs

Part Name: Lid Prop Assembly 6.69"



Part Weight: 0 lbs

Status: New

Priority: Medium

Job Created: 1/6/20

Job Tracking No:

Due Date: 1/30/20

Created By: Marie Lajeunesse

Type: SOLD

Description:

Note: DWG REV C1 IPP: B 02.08.12 Re-format; Incorporated D2332-13/-11/-7/-5 KJ/RF IPP Rev:C 08-06-02 add comment DD verified by:EC

Ship Via:

Bill of Materials

Job Routing

Op No	Operation	Qty	Start Date	Due Date	Standard		Workcenter/Supplier		Sign-off
					Setup Hrs	Run Hrs	Workcenter / Supplier	Lead Time	
100	Small Fab - 1	6 pcs	1/30/20		0.32	1.88	Small Fab - 1		
							Small Fab - 2		
							Small Fab - 3		
							Small Fab - 4		
							Small Fab - 5		
							Small Fab - 6		
							Small Fab - 7		
							Small Fab - 8		
							Small Fab - 9		GP 20-02-18
							Small Fab - Various 1		
110	Small Fab - Brake NC - B4B	6 pcs	1/30/20		0.25	0.68	Small Fab - Brake - 1 - B4B		
							Small Fab - Brake - 2 - B4B		
							Small Fab - Brake - 3 - B4B		GP 20-02-18
							Small Fab - Various 1 - B4B		
120	Small Fab - 2 - B4B	6 pcs	1/30/20		0.00	1.88	Small Fab - 1 - B4B		
							Small Fab - 2 - B4B		
							Small Fab - 3 - B4B		
							Small Fab - 4 - B4B		
							Small Fab - 5 - B4B		
							Small Fab - 6 - B4B		
							Small Fab - 7 - B4B		
							Small Fab - 8 - B4B		
							Small Fab - 9 - B4B		GP 20-02-18
							Small Fab - Various 1 - B4B		
			1/30/20		0.00	0.00	QC 5 - 10		
							QC 5 - 12		
							QC 5 - 17		
							QC 5 - 18		



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Container No: S256113



Part: D2332-041

Job No: 205242

Serial No/Batch: S256113

Revision:

Inspector:

Exp Date:

Instructions: Various STC's

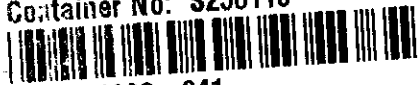
Date: 02/28/20

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DART
AEROSPACE

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Container No: S256113



Part: D2332-041

Job No: 295242

Serial No/Batch: S256113

Re Issue:

Insp:

Exp:

Instructions: Various STC's

Date: 02/14/20

				QC 5 - 19	
				QC 5 - 22	
				QC 5 - 24	
				QC 5 - 3	
				QC 5 - 43	
				QC 5 - 49	
				QC 5 - 51	
				QC 5 - 58	
				QC 5 - 68	
				QC 5 - 9	
				QC 5 - 50	
				QC 5 - 30	
				QC 5 - 40	DAS FEB 20 2020 40
				QC 5 - 61	8-89
				QC 5 - 81	
140 Large Fab - Welded Assy-2-B4B	6 pcs	1/30/20	0.00 1.49	Large Fab - 1 - B4B	
				Large Fab - 10 - B4B	
				Large Fab - 2 - B4B	MV Feb 26/20
				Large Fab - 3 - B4B	
				Large Fab - 4 - B4B	
				Large Fab - 5 - B4B	
				Large Fab - 6 - B4B	
				Large Fab - 7 - B4B	
				Large Fab - 8 - B4B	
				Large Fab - 9 - B4B	
				Large Fab - 11 - B4B (Various)	
				Large Fab - 12 - B4B	
150 QC 9	6 pcs	1/30/20	0.00 0.00	QC 9 - 10	
				QC 9 - 18	
				QC 9 - 24	
				QC 9 - 43	
				QC 9 - 50	CL
				QC 9 - 9	
160 QC 5	6 pcs	1/30/20	0.00 0.00	QC 5 - 10	
				QC 5 - 12	
				QC 5 - 17	
				QC 5 - 18	
				QC 5 - 19	
				QC 5 - 22	
				QC 5 - 24	
				QC 5 - 3	
				QC 5 - 43	
				QC 5 - 49	
				QC 5 - 51	
				QC 5 - 58	
				QC 5 - 68	
				QC 5 - 9	
				QC 5 - 50	CL
				QC 5 - 30	
				QC 5 - 40	
				QC 5 - 61	
				QC 5 - 81	
170 Small Fab - 3 - B4B	6 pcs	1/30/20	0.00 1.88	Small Fab - 1 - B4B	
				Small Fab - 2 - B4B	
				Small Fab - 3 - B4B	
				Small Fab - 4 - B4B	
				Small Fab - 5 - B4B	
				Small Fab - 6 - B4B	

				Small Fab - 7 - B4B	
				Small Fab - 8 - B4B	
				Small Fab - 9 - B4B	
				Small Fab - Various 1 - B4B	
180	QC 5	6 pcs	1/30/20	0.00 0.00	QC 5 - 10
					QC 5 - 12
					QC 5 - 17
					QC 5 - 18
					QC 5 - 19
					QC 5 - 22
					QC 5 - 24
					QC 5 - 3
					QC 5 - 43
					QC 5 - 49
					QC 5 - 51
					QC 5 - 58
					QC 5 - 68
					QC 5 - 9
					QC 5 - 50
					QC 5 - 30
					QC 5 - 40
					QC 5 - 61
					QC 5 - 81
190	Packaging 3-1 - Stock - B4B	6 pcs	1/30/20	0.00 0.00	Packaging 3 - 1 - B4B
					Packaging 3 - 2 - B4B
					Packaging 3 - 3 - B4B
					Packaging 3 - 4 - B4B
					Packaging 3 - 5 - B4B
					Packaging 3 - 6 - B4B
					Packaging 3 - 7 - B4B
					Packaging 3 - 8 - B4B
					Packaging 3 - 9 - B4B
					Packaging 3 - 10 - B4B
					Packaging 3 - 11 - B4B
					Packaging 3 - 12 - B4B
					Packaging 3 - 13 - B4B
					Packaging 3 - 14 - B4B
					Packaging 3 - 15 - B4B
					Packaging 3 - 16 - B4B
					Packaging 3 - 17 - B4B
					Packaging 3 - 18 - B4B
					Packaging 3 - 19 - B4B
					Packaging 3 - 20 - B4B
					Packaging 3 - 21 - B4B
					Packaging 3 - 22 - B4B
					Packaging 3 - 23 - B4B
					Packaging 3 - 24 - B4B
					Packaging 3 - 25 - B4B
					Packaging 3 - 26 - B4B
					Packaging 3 - 27 - B4B
					Packaging 3 - 28 - B4B
					Packaging 3 - 29 - B4B
					Packaging 3 - 30 - B4B
					Packaging 3 - 31 - B4B
					Packaging 3 - 32 - B4B
					Packaging 3 - 33 - B4B
					Packaging 3 - 34 - B4B
					Packaging 3 - 35 - B4B

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				Packaging 3 - 36 - B4B	
				Packaging 3 - 37 - B4B	
200 QC 21 - SA	6	1/30/20	0.00 0.00	QC 21 - SA - 21	
	pcs			QC 21 - SA - 70	DAS
				QC 21 - SA - 53	21 MAR 24 2020

Part Op 100 - (Small Fab) 1- Cut D2332-7 and D2332-5 to length as per dwg D2332. 2- Cut D2332-11 using 1/2" S.S tubing
 Descriptions: 7.735" long. 3- Deburr.

110 - (Punch ends and deburr as per dwg) Punch and form D2332-11 to length as per dwg D2332 using DT8012 (need 2 per ass'y)

120 - (Small Fab) 1- Drill hole in D2332-11 as per dwg D2332 using drill jig DT8459 (drill one per ass'y) 2- Ensure no foreign objects inside tube

130 - (QC5- Inspect part completeness to step on W/O)

140 - (Weld per dwg A/R S.S. rod Batch: M36585) Weld D2332-11 and D2332-5 as per dwg (weld 1 per ass'y)
 *****ensure nothing is inside of tube before welding***** S.S Rod batch: _____

150 - (QC9- Inspect visual per QSI004- Fusion Welds)

160 - (QC5- Inspect part completeness to step on W/O)

170 - (Small Fab) 1- Tumble 2- Assemble as per dwg D2332

180 - (QC5- Inspect part completeness to step on W/O)

190 - (Identify as per dwg & Stock Location: _____)

200 - (QC21- Final Inspection - Work Order Release)

Job BOM

Part / Item	Component Name	Quantity	Operation	Container
M304R0.250	304 SS Round bar .250	.6000 ft (.1 ea)	100-Small Fab - 1	243099 243099
M304TR1.000W.049	304 Round Tube 1.00 X .049W	2.5800 ft (.43 ea)	100-Small Fab - 1	200698
M304TR0.500W.035	304 Round Tube .500 X .035W	7.5000 ft (1.25 ea)	110-Small Fab - Brake NC - B4B	255410
AN4-4A	Bolt 24 003 345	6 Ea (1 ea)	170-Small Fab - 3 - B4B	255237 23733x3. 193116x3.
MS21042L4	Nut 007	6 Ea (1 ea)	170-Small Fab - 3 - B4B	225039
NAS1149D0416J	Washer ST264.	18 Ea (3 ea)	170-Small Fab - 3 - B4B	FM131511

Job Allocations

Operation	Component Part	Required	Inventory	Allocated
100-Small Fab - 1	M304R0.250	1	14	0
	M304TR1.000W.049	3	20	0
110-Small Fab - Brake NC - B4B	M304TR0.500W.035	8	98	0
170-Small Fab - 3 - B4B	AN4-4A	6	120	0
	MS21042L4	6	2,658	0
	NAS1149D0416J	18	1,603	0

Part Specifications

Spec No	Description	Target/Tolerance	Limits	Type	Special Comments
1	Lid Prop Assembly	5.000Inches ± 0.030	5.030 4.970		
2	Lid Prop Assembly	1.250Inches ± 0.010	1.260 1.240		
3	Lid Prop Assembly	6.690Inches ± 0.010	6.700 6.680		

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Entered: _____ Date: _____



WORK ORDER NON-CONFORMANCE / ROUTE UPDATE

NCR No. _____

Route update only ☐

Job: _____ Part No. _____	DISPOSITION Rework ☐ Scrap ☐ Use-as-is ☐	DEPARTMENT/PROCESS Skid-tube ☐ Machining ☐ Large Fab ☐ Cross tube ☐ Small Fab ☐ Finishing ☐ Eng. (Non-AW) ☐ Prod. Eng. Coord. ☐ Rec/Store/Packaging ☐ Engineering ☐ Water Jet ☐ Supplier ☐ Quality ☐			
Date : _____	Sequence #: _____	QTY Affected : _____		MRB (QSI042)	
Description Work Order Deviation		Disposition		Completed By	
				Lead hand / Supervisor	
				QC / QA Coordinator	
Root Cause Operator ☐ Manufacturing Process ☐ Equip/Tooling ☐ Handling/Presservation ☐ Material ☐ Product Improvement ☐ Process Improvement ☐ Human Factors ☐		FAULT CATEGORY ☐ Pressure/Forced ☐ Bending ☐ Crushing ☐ Cracks ☐ Crimp/Kink/Ripple/Wave/Twist ☐ Marks/Chatter ☐ Mislabeled ☐ Contamination ☐ Misaligned/off center ☐ BOM/Route ☐ Broken/Damage/Defect ☐ Incomplete/Unclear Instructions ☐ Drill Holes ☐ Fit/Function ☐ Power Loss/Surge ☐ Folio/Program ☐ Grain Direction ☐ Weld ☐ Wrong Stock Pulled ☐ Out of Sequence ☐ Off-set/Set-up ☐ Positioned Wrong ☐ Outside Tolerance ☐ Drawing ☐ Finish ☐ Part Lost/Missing ☐ Misread			
Other/Details:					